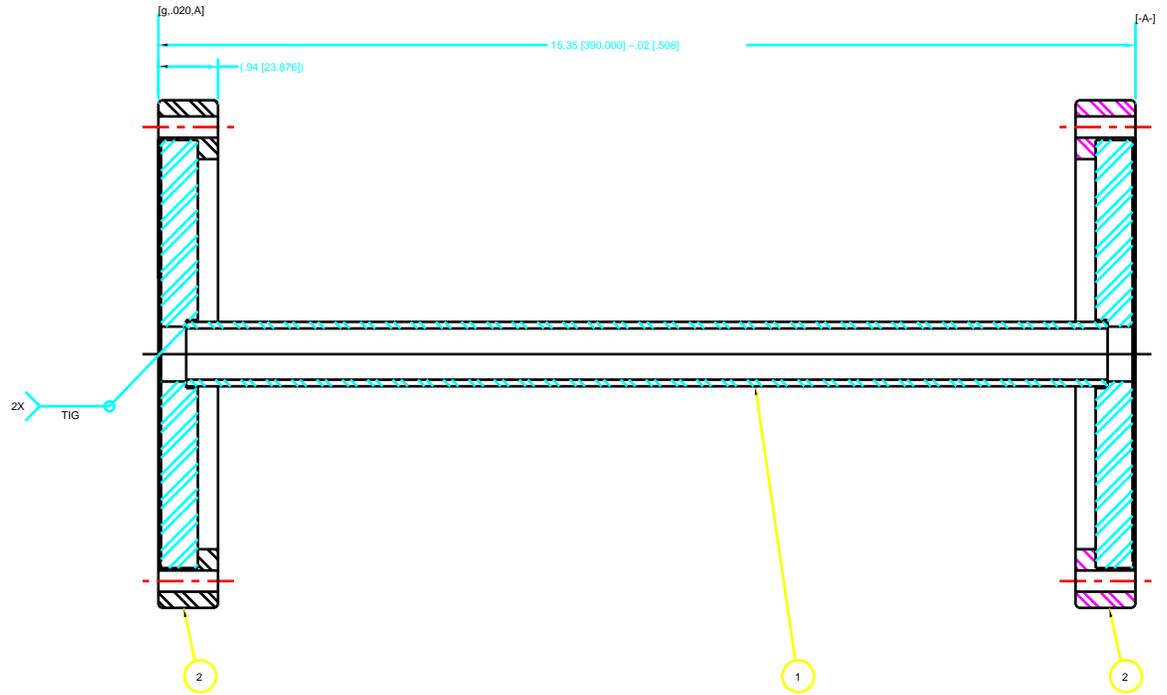
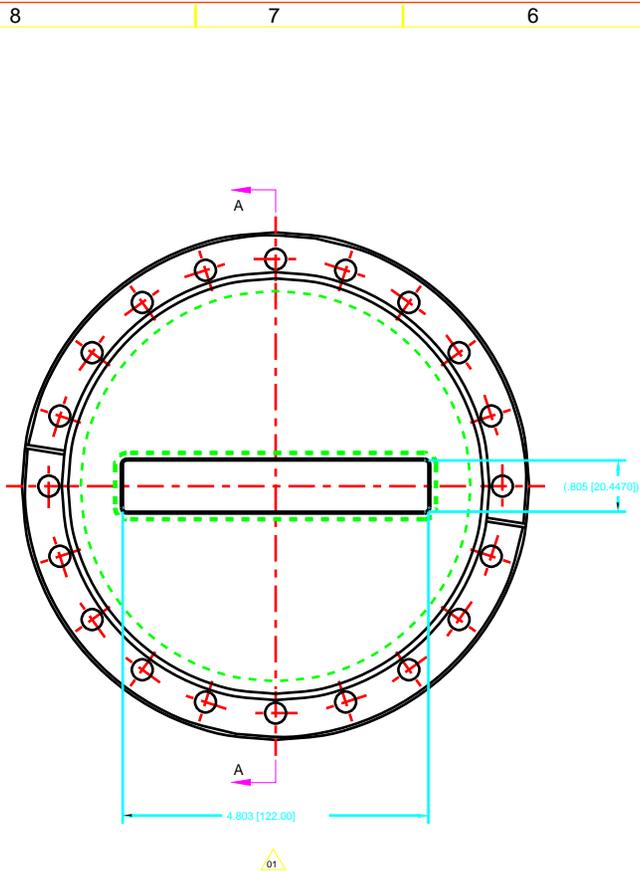


(\varnothing)	PLOT SCALE: 1=1	DWG. SCALE: 1	A09895
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SECTION A-A

NOTES:

1. MODIFY FROM PURCHASED PART:
ROTATABLE FLANGE; MDC #100030
2. CHAMBER ASSEMBLY SHALL BE LEAK TESTED USING A MASS SPECTROMETER WITH MINIMUM SENSITIVITY FOR HELIUM OF 2 x 10 STANDARD CC/SEC PER LEAK METER DIVISION, SUCH AS:
ALCATEL SAM-110TCL
DUPONT CEC 24-120B
VARIAN MS-9, MS-90 OR MS-18
CALIBRATION OF THE LEAK DETECTOR SENSITIVITY SHALL BE PERFORMED JUST PRIOR TO TESTING.
FINAL TESTING WILL CONSIST OF SURROUNDING THE CHAMBER (BAGGING) WITH HELIUM. THE CHAMBER WILL BE REJECTED IF A 2% DEFLECTION ON THE MOST SENSITIVE RANGE OF THE LEAK DETECTOR IS SENSED WITHIN 1 MIN.
3. KEEP THE PART CLEAN, AND WRAP FOR UHV PACKING WITH ALUMINUM FOIL.
4. DIMENSIONS IN [] ARE MILLIMETERS AND FOR REFERENCE ONLY.

01
01

2	P4102020102-220102-01	K2 END FLANGE	SST	2	
1	P4102020102-220101-01	K2 RECTANGULAR TUBING	SST	1	
ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY	
PARTS LIST					
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES		LOG NUMBER A0989501	THIS DRAWING IS THE PROPERTY OF ARGONNE NATIONAL LABORATORY		
TOLERANCES: DECIMALS ANGULAR X .010 - .05 XX .005 - .02 XXX .002		DRAWN BY RICK KRAKORA	DATE 4/93	CHIEF DESIGN ENGINEER D. SHU	DATE 4/28/93
SURFACE ROUGHNESS 125		DESIGNED BY T. SANCHEZ	DATE 4/27/93	PROJECT MGR. T.M. KUZAY	DATE 4/28/93
REMOVE ALL BURRS AND BREAK SHARP EDGES (R0.04)		DESIGNER RICK KRAKORA	DATE 4/93	APPROVED/RELEASED	
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1		RESPONSIBLE ENGINEER T. SANCHEZ	DATE 4/27/93		
DIMENSIONS & TOLERANCES IN ACCORDANCE WITH LATEST ANSI Y14.5		MATERIAL SEE B.O.M.			
DO NOT SCALE DRAWING		SCALE 1=1	SHEET 1 of 1	DRAWING NUMBER P4102020102-220100-01	

01	4.803 WAS 5.197 & UPDATED BOM	DB			
BYM	CHANGE DESCRIPTION	BY	CHKD	DATE	
REVISIONS					

ADVANCED PHOTON SOURCE

K2 B.M. SECOND COLLIMATOR
VACUUM CHAMBER
WELDMNT ASSEMBLY